

Work Order ID 81678

March-16-12 1:58:14 PM

81678

Page 1

Item ID: D5951

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, 205

Start Date: 16/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 12/03/16

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D5951

Rev B

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio D5951, Ensure Batch Number is entered
2-Machine Keyway3-Deburr & Tumble

110

0.00

110

QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

8 76 12625

140 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

140

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:20 OVEN TEMPERATURE:
FINISH TIME: 10:30

8 6 12626

150 QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

8 6 126126

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>430</u>	0.00				<u>80</u>			<u>12/6/23</u>
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							<u>12/6/28</u>
170									
QC	Memo	0.00							
Quality Control									<u>mf</u> <u>12-06-27</u>

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 81678

81678

Parent Item: D5951

D5951

Parent Item Name: Saddle, 205

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:E Re-Format 05-11-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-013		Manufactured	No			100	Each	7.0000	1	6			

D6101-013

Saddle Billet

Location

Loc Qty

Loc Code

MAT047

7

46413

7

81925X8

and 12/06/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81678
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.437	0.444		.441	.440	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.320	.320	.320	.320		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		.320	.320	.320	.320		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.500	.500	.500	.500		
N	1.615	1.635		1.630	1.630	1.630	1.630		
O	7.990	8.010		8.001	8.001	8.000	8.000		
P	2.240	2.260		2.253	2.250	2.250	2.257		
Q	0.307	0.312		.310	.310	.309	.309		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.500	.500	.500		
T	1.375	1.395		1.382	1.382	1.3825	1.383		
U	2.000	2.020		2.002	2.001	2.0016	2.0026		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	amf
Date:	12/06/20

Audited by:	SL
Date:	12-06-25

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order:	81678
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.437	0.444		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
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F	4.745	4.755		4.750	4.750	4.750	4.750		
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L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.500	.500	.500	.500		
N	1.615	1.635		1.630	1.630	1.630	1.630		
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P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.501	0.501	0.501	0.501		
T	1.375	1.395		1.382	1.382	1.382	1.382		
U	2.000	2.020		2.006	2.002	2.003	2.003		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

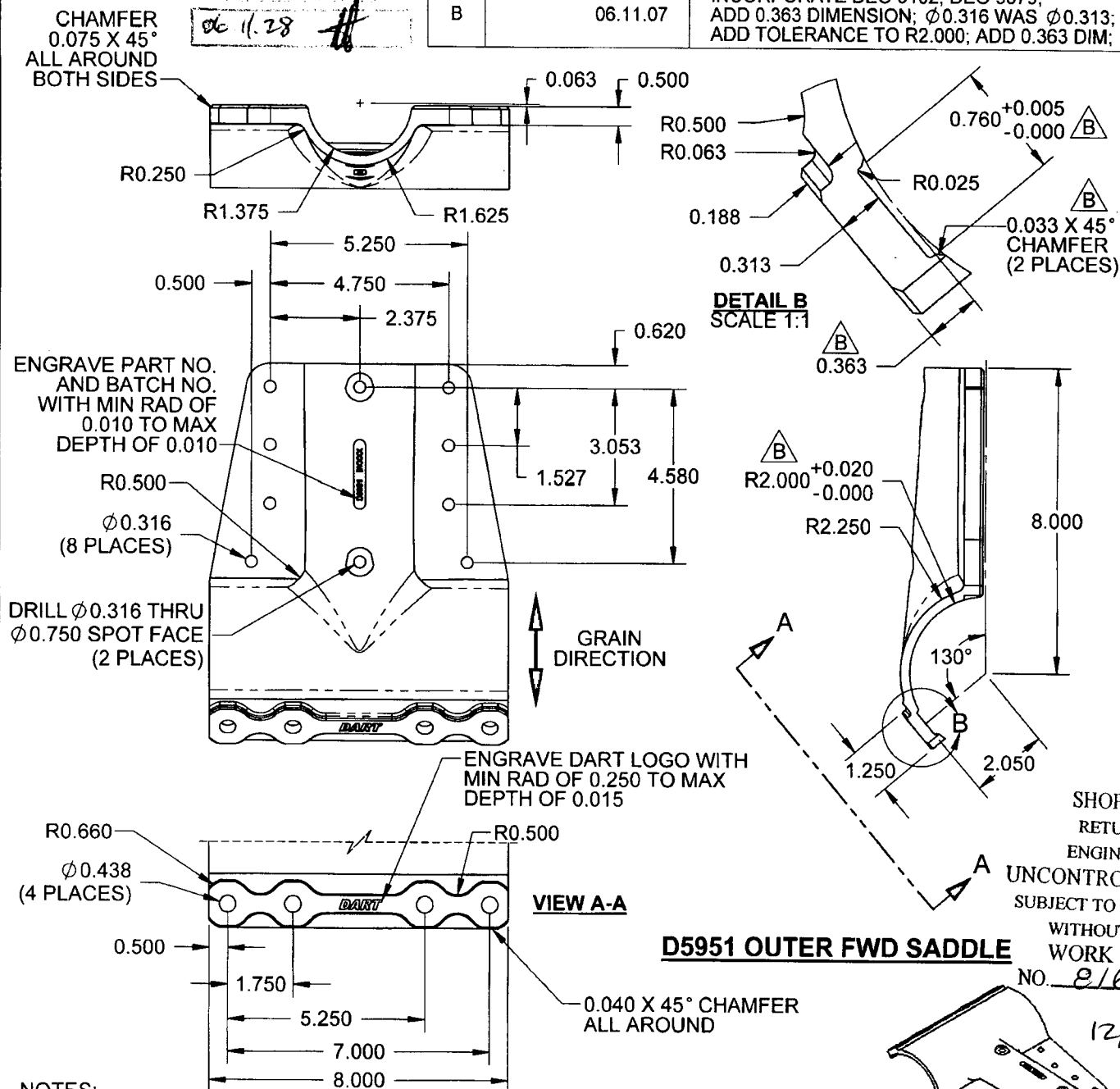
Measured by:	SMF
Date:	12/06/19 / 12/06/21

Audited by:	ST
Date:	12-06-25

Rev	Date	Change	Revised by	Approved
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DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5951	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER FWD SADDLE		
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;	



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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